

Date: Thursday, 27/11/2008 2:23:36 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CROSSBOLT SPACER
 Job Number : 43803
 Estimate Number : 11010
 P.O. Number :
 This Issue : 27/11/2008 S.O. No. :
 Prsht Rev. : NC Drawing Number : D2649 REV B1
 First Issue : // Type : MACHINED PARTS Project Number : N/A
 Previous Run : 43505 Drawing Revision : B1
 Material :
 Due Date : 10/12/2008 Qty: 300 Um: Each
 Written By :
 Checked & Approved By : 540 08.11.27
 Comment : Est F 02.03.26 Added turning on Cobra NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T0375W058 6061-T6 RD Tube .375 x.058W



Comment: Qty.: 0.2975 f(s)/Unit Total: 89.2395 f(s)

6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

Batch M107514 - 12 ft
M109314 - 41.2395
M108380 - 36 ft 300 pcs

08/11/29

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA214 on cobra machine.

08/11/29

300 pcs

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/11/29

300 pcs

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

3.2 08/11/30

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location BA they

8/12/1

50

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/01

Job Completion



WVF 08-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

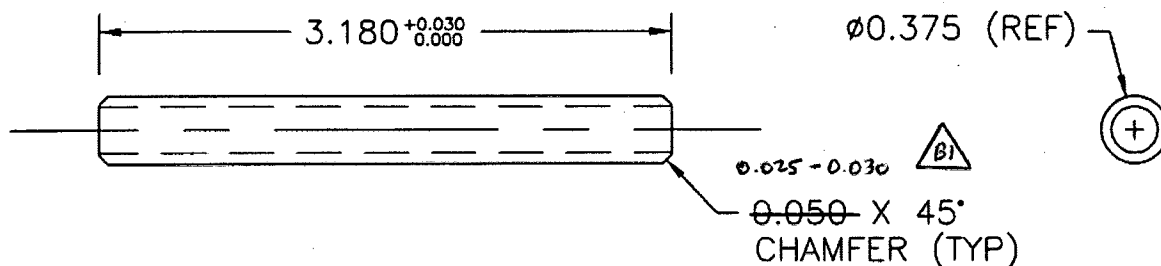
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
BI	# CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43803

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED